

Split ②

Work Order ID 53880 - 2

November 23, 2009 11:02:18 AM



Page 1

Item ID: D4013-041

Accept



Setup Start



Revision ID:

Item Name: Wearplate Assembly

Stop



Start Date: 11/26/2009 Start Qty: 12.00

Required Date: 12/2/2009 Req'd Qty: 12.00

⑧



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 09-11-23, Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4013

C

100

0.00



Waterjet

Memo

0.00

IB 9-11-25

FLOW CNC Waterjet

1-Cut as per Dwg D4013-1

Dwg Rev: *E*

Prog Rev: *E*

2-Deburr if necessary

②

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

IB 9-11-25

Quality Control

Work Order ID 53880

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Page 3

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Start Date: 11/26/2009 Start Qty: 12.00

Required Date: 12/2/2009 Req'd Qty: 12.00

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Large Fab

Large Fab

Memo

0.00

1- Weld cup, stud as per dwg use DT9550

A/R S.S. ROD BATCH: M108160

2- Apply hardfacing on wearplate and on studs (studs only 5 places not the cups)
as indicated on dwg

A/R HARDCOAT 2059B BATCH: M113521

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ 8/10/01/29

170



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

8/10/01/29

10-1-25
x8

x8

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Page 4

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Accept



Setup Start



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Required Date: 12/2/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

180



Powdercoat

Powder Coating

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

0.00

***MASK THREADS AND HEXAGONAL OPENING PRIOR TO
PAINTING***

START: 8:30 AM

Temp: 320°F

FIN: 9:00 AM

10-02-01 x 8 q

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

OK 10-02-01

⑧

200



Packaging

Packaging

Identify as per dwg & Stock Location: 256

0.00

Memo

0.00

Rec'd 2/3 ⑧

Work Order ID 53880

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Page 5

Item ID: D4013-041

Accept



Setup Start



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Start Date: 11/26/2009 Start Qty: 12.00



Required Date: 12/2/2009 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/03
ME
10-2-3

Picklist Print

November 23, 2009 11:02:18 AM

Page 1
2

Work Order ID: 53880

Parent Item: D4013-041

Parent Item Name: Wearplate Assembly

Comments: IPP RevA: New issue 09.10.26 DD verified by:JLM
RevB prelim per ECN09-698p 09.11.02 DD verified
by:EC
redesign 09.11.12 DD verified by:EC

IPP RevB:

IPP RevC:

IPP RevD: revC as per

Start Date: 11/26/2009

Required Date: 12/2/2009

Start Qty: 12.00

Required Qty: 12.00

M304S16GA

Purchased

No

100

sf

113.8637

12.2526



304/316 Sheet .063

B9-11-2

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

113.863737

106860

16.018

111924

25.1689737

112442

29.8899

112567

0.2973

112885

42.4895

112885

D4013-3

Manufactured

No

150

Each

20.0000

36.0000



Stud

EL

9-12-7

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

20

20

150

Each

0.0000

72.0000

D4013-5

Manufactured

No



Cup

EL

9-12-7

7 X 53 940
17 X 54675

EL 10-1-18

53 827 X 3
53940 X 33

22 X 53941
26 X 54676

EL 10-1-18

53 828 X 8
53941 X 64

Picklist Print

November 23, 2009 11:02:18 AM

Page 2

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RevB prelim per ECN09-698p 09.11.02 DD verified
by:EC
redesign 09.11.12 DD verified by:EC

IPP RevB:

IPP RevC:

IPP RevD: revC as per

Start Date: 11/26/2009

Start Qty: 12.00

Required Date: 12/2/2009

Required Qty: 12.00

D4013-9

Manufactured No

150

Each

41.0000

24.0000



Stud



EL 9-12-7

9x 53948
7x 54677

EL 10-1-18

Warehouse

Location

Main Warehouse

ST

53829

Loc Qty

Loc Code

53948

x21

41

41

+3

150

Each

0.0000

24.0000

D4013-11

Manufactured No



Stud



EL 9-12-7

8x 53954
8x 54679

EL 10-1-18

B53830 x22

B53954 x22

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Shop Packet Print

Page 2

DART AEROSPACE LTD		Work Order: 53880
Description: WEAR PLATE		Part Number: D40B-041
Inspection Dwg: D40B-1 Rev: C		Page 1 of 1

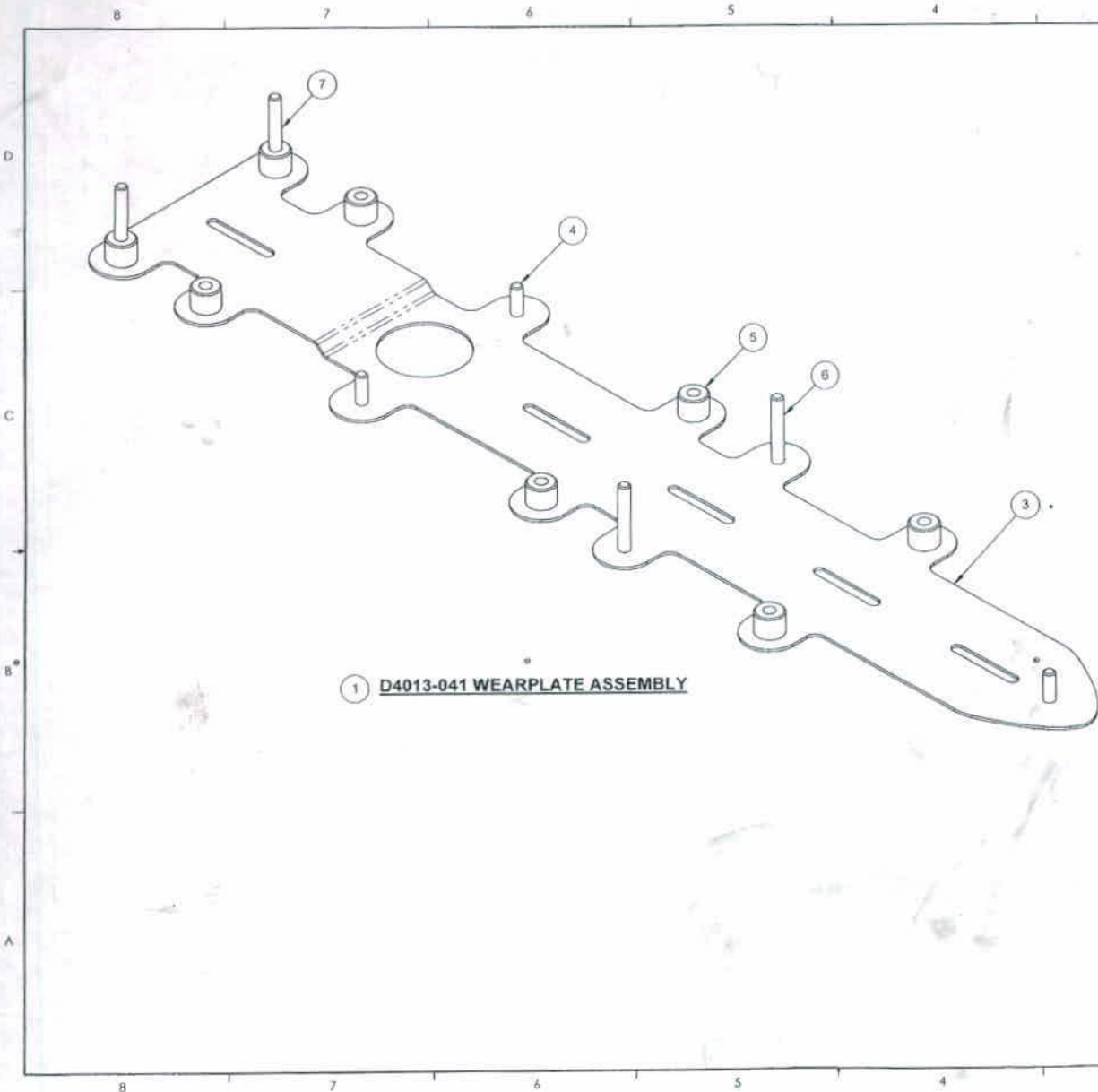
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .250	+ .005 - .001	.254	X			
Ø .625	+ .008 - .001	.627	X			
Ø 1.88	+ .012 - .001	1.880	X			
.250	± .010	.253	X			
1.750	± .010	1.754	X			
1.50	± .030	1.503	X			
2.125	± .010	2.128	X			
2.75	± .030	2.75	X			
.625	± .010	.625	X			
2.438	± .010	2.434	X			
6.876	± .010	6.876	X			
7.271	± .010	7.270	X			
12.146	± .010	12.146	X			
14.458	± .010	14.458	X			
18.458	± .010	18.458	X			
23.958	± .010	23.958	X			
25.04	± .030	25.04	X			
.063	± .010	.060	X			

Measured by: WB	Audited by: S	Prototype Approval:	N/A
Date: 9-11-22	Date: 07/12/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



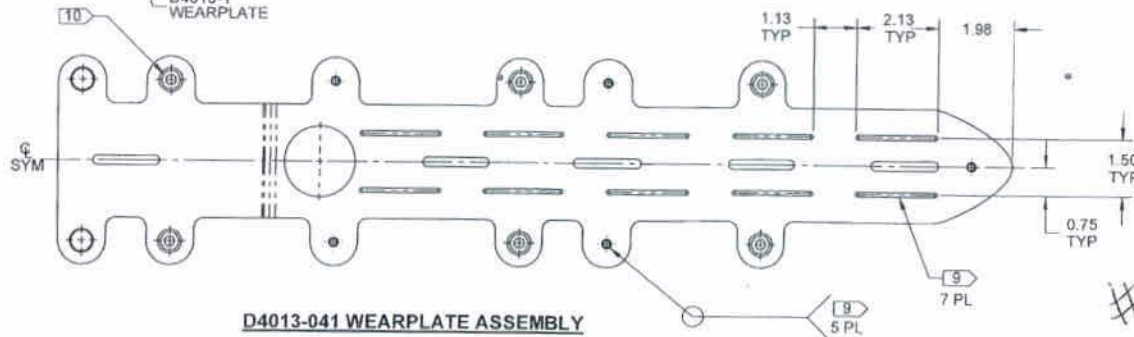
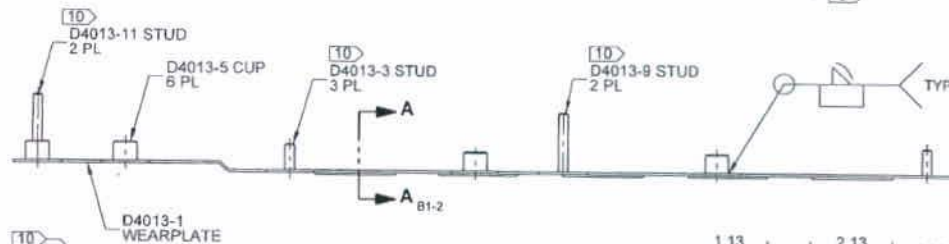
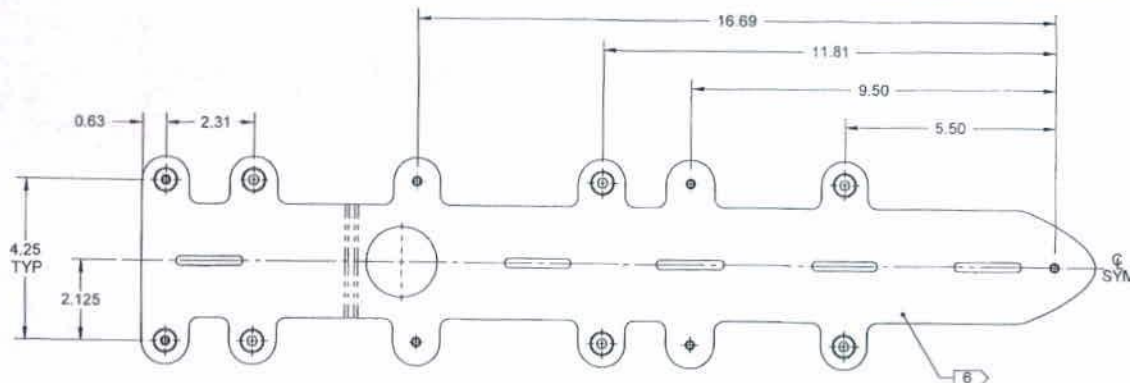
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4013-041	WEARPLATE ASSEMBLY
3	1	D4013-1	WEARPLATE
4	3	D4013-3	STUD
5	6	D4013-5	CUP
6	2	D4013-6	STUD
7	2	D4013-11	STUD
21	A/R	2059B	HARDCOAT

#53880

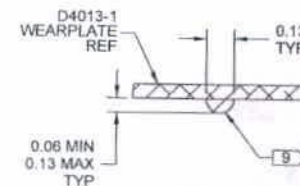
1 D4013-041 WEARPLATE ASSEMBLY

RELEASED
2009-11-24

C	SIMPLY DESIGN FOR MANUFACTURING PURPOSES; REDESIGNED ITEM 5, ELIMINATED D4013-7 CUP (NO LONGER USED); CHANGED FINISH FROM GREY TO BLACK SANDING	MB	09.11.11
B	REDESIGN	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4013 SHEET 1 OF 5 TITLE WEARPLATE ASSEMBLY SCALE NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OTHER THAN THAT AUTHORIZED BY DART AEROSPACE LTD.</small>			



D4013-041 WEARPLATE ASSEMBLY



SECTION A-A B6-2
SCALE 8X

RELEASED
2009-11-24

NOTES:

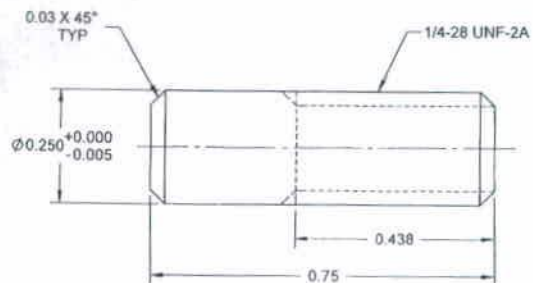
- 1) MATERIAL: SEE SHEETS 3 AND 4
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4013-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.89 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 10 PL
- 10) MASK THREADS (7 PL) AND HEXAGONAL OPENINGS (6 PL) PRIOR TO PAINTING

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4013	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	09.11.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD	

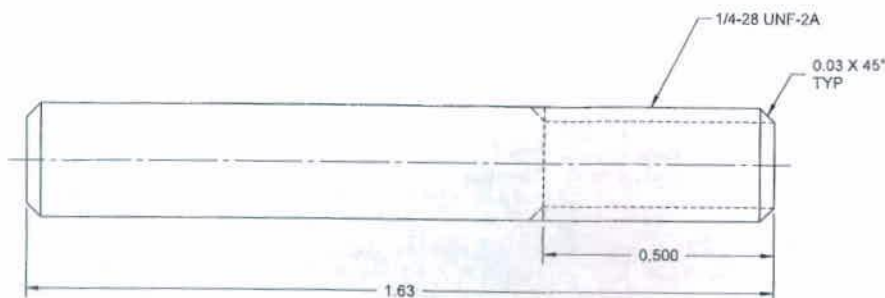


RELEASE
2009-11-24

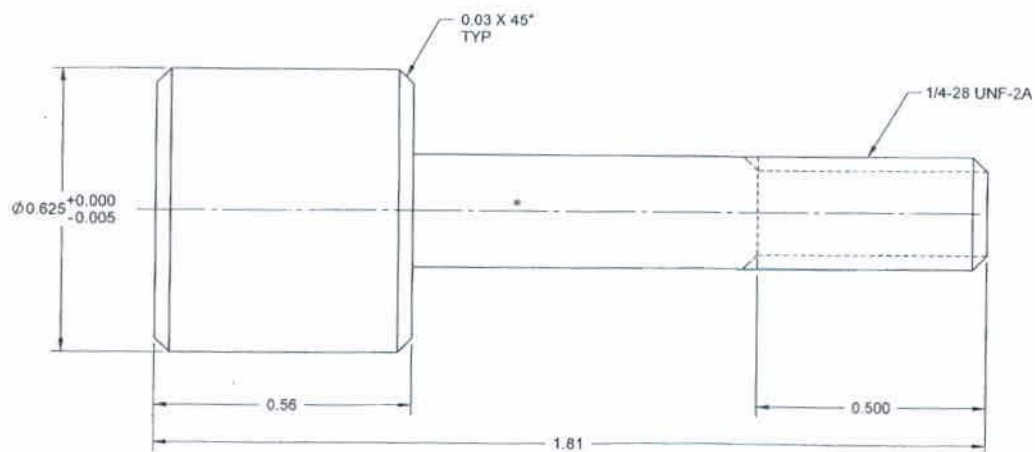
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.S.	DRAWING NO.	REV. C
MFG. APPR.	D.S.	D4013	SHEET 3 OF 3
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DE APPR.	[Signature]	WEARPLATE ASSEMBLY	NTS
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D4013-3 STUD



D4013-9 STUD



D4013-11 STUD

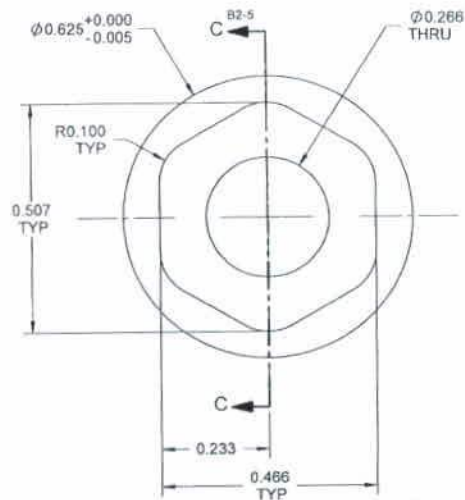
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: LESS THAN 0.01 LBS EACH

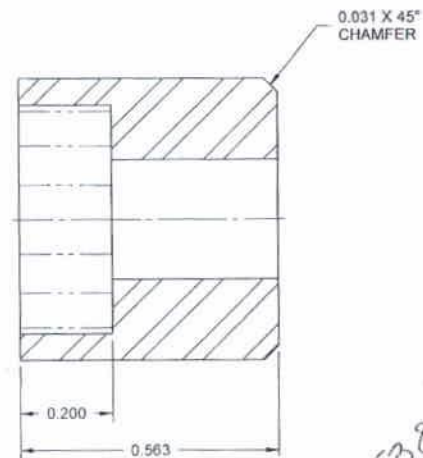
#53880

RELEASED
2009-11-24

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4013	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
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D4013-5 CUP



SECTION C-C D6-5

#53880

RELEASED
2009-11-24

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs EACH

DESIGN	LA	DART AEROSPACE LTD	
DRAWN	LA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO. D4013	REV. C
MFG. APPR.	DS		SHEET 5 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	WEARPLATE ASSEMBLY	NTS
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